Work Orde October-12-12 1				*91	554	1*						Page 1
tem ID: Revision ID:	D2932-1		Α	ccept	*	1 900	040	100)* s	etup Start	*N:	S1*
tem Name:	Saddle LH O	ut, 206								Stop	*N:	S2*
Start Date:	10/11/12	Start Qty: 4.00	*4*		•	Cust Item II	D:					
Required Date:	11/02/12	Req'd Qty: 4.00	*4*			Customer:						
Reference:										~		
Approvals:	Process Pl	an: _ MLJ	Date: 12-10-12	Tooling:		Da	ite:		R	un Start	17	R1*
	QC:	·	Date:	SPC (Y/N):		Da	ite:			Stop	*N	R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	······································	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Re	vision Nbr			,							
D2932	Re	v C										
100				0.00								
100 HAAS I		HAAS CNC VERTICAI	L MACHINING #1	0.00	Fik	13/01/	110		4	\$		
HAAS CNC vertical	machine #1	number are inspect as p	rt number and batch number. programmed correctly.2-Ma er dwg D2932 & attached Di I visually inspect as per	chine Step No 1 of	Folio and v	isually						
110				0.00								
110		CONVENTIONAL MIL	LING MACHINE		EI.	19 / / .			4	de		
Mill Conv		Memo		0.00	Tity	13/01/10	>			7		·
Conventional Millin	g Machine	Machine K	eyway and inspect per attache	ed dimension sheet					•			
120		QC1- Inspect dimension	ns to dimension sheet	0.00						J		
120 QC QC		Мето		0.00	EK 1	3/01/10)		_9			

Quality Control

		DQA:	Date:	
JCR· Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

											QA Closed:	Date	<u>;</u>
Work Orde	er:		_			DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part f	No.	•••				Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Do ot		1	T		Docor	iption of work order update		nitial	۸	ction	Sign &		
Root		Data	Ston	O+1/		or Non-conformance	· .	ef Eng		cription	Date	Verification	QC Inspector
Cause Doc/Data	Г	Date	Step	Qty		or Non-comormance	CIII	er Eng	Desc	ription	Date	Vermeation	QC IIISPECTOI
	-											<u> </u>	
Equip/Tooling Operator							1						
Material		1										1	
Setup													
Other	-									•			
Process													
Supplier													
Training			1										
Unapproved		1							1				
		•		•		F	AUL	T CATE	GORY				
Landi	ng (Gear				General		·			_		
	Γ	Bending				Bend ·		Grain			Ovalized		Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged (Inspect	ion Incomplete		Part Incorre	ct	Weld
	L	Crushed/	Crimped			Burrs		Instruct	ions Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs			L	Contamination	Ш	Mainte	enance		Part Moved		
		Heat Trea	at			Countersink		Mislabe			Positioned V		
1	L	Inspection	•	Tube		Cut Too Short	\vdash	Misrea	t		Power Loss/	/Surge	Other
	_	Ripples in				Drill Holes Drawing	\vdash	Offset					
		Torque W			ո ՝ L		—		Calibration				
	L	Turning S	•			Finish	-		Sequence				
		Wave/Tw	ist in Tul	oe		Folio		Outside	Dimensions				

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Work Order 1	D 915	554
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Powder Coating

91554

Page 2

October-12-12 12:34:20 PM Item ID: D2932-1 Accept *N900040100* Setup Start **Revision ID:** Saddle LH Out, 206 Item Name: *4* Start Qty: 4.00 **Start Date:** 10/11/12 **Cust Item ID:** Required Date: 11/02/12 Req'd Qty: 4.00 **Customer:** Reference: Run Start Process Plan: Date: **Tooling:** Approvals: Date: Stop SPC (Y/N): QC: Date: Date: Reject Sequence ID/ Tool ID Tool # Plan Reject **Operation** Set Up/ Accept Insp. Qty Qty Work Center ID Number Stamp Description **Run Hours** Code 130 QC8- Inspect parts - second check 0.00 *130* 13/01/10 QC 0.00 Memo Quality Control 140 Chemical Conversion Coat per QSI005 4.1 0.00 4 3 13.1.11 *140* HandFinish 0.00 Memo Hand Finishing White Gloss (Ref. 4.35.1) per QSI005 4.3-Alum 150 0.00 H & BR 13-1-14 *150* Powdercoat 0.00

											DQA:	Date	:	
NCR:	Yes	/ No				WORK ORDER NON-C	O	NFORN	MANCE / UPDATE					
	·					T				_	QA Closed:	Date	2:	
Work Orde	er.					DISPOSITION			AGAINST	DEI	PARTMENT	/PROCESS		
Part f	_ No	_				Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite		!	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
											·			
Root					Descri	ption of work order update	1	nitial	Action		Sign &	:		
· Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspec	tor
Doc/Data	Ш													
Equip/Tooling	Ш							ŀ						
Operator	Ш													
Material	Ш									1				
Setup	Ш													
Other	Ш						1	-1]		
Process	Ш						1						- [
Supplier	Ш													
Training	Ш													
Unapproved		· · · · · · · · · · · · · · · · · · ·					<u> </u>				l			
							AUL	T CATE	GORY	_				
Landi					,	General		1 .	,		1	г	-	
	-	Bending				Bend	<u> </u>	Grain		<u> </u>	Ovalized	1	Pressure/Force	
	\mathbf{H}	Centre No	t Concer	itric to	o/s	BOM/Route	_	Hardwa		<u> </u>	Over/Under	-	Temperature/0	Lure
	\vdash	Cracks				Broken/Damaged	_	i `	on Incomplete	_	Part Incorre	j	Weld	
	\vdash	crushed/0	Crimped.			Burrs		-1	ions Incomplete/Unclear		Part Lost/M	- L	Wrong Stock P	ulled
	Щ	Cuffs				Contamination		Mainte		<u> </u>	Part Moved			
	۲	leat Trea	t			Countersink		Mislabe	led	L	Positioned V	Wrong _		
	1 16	nspection	Strin in	Tuhe	1	Cut Too Short	1	Misreac	{	i	Power Loss/	Surge	Other	

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

Work Orde				*915	554*							Page 3
Revision ID:	D2932-1 Saddle LH O	ut, 206		Accept	*N900	040	100)*	Setup	Start Stop	*N:	S1* S2*
	10/11/12	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	ID:						12
Approvals:	Process Pl	an:	Date:	Tooling:	D	ate:			Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):	D	ate:				Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Re Qt		Reject Number	Insp. Stamp
*160 *160* QC Quality Control		QC3- Inspect Part Finish Memo	1	0.00				4x				3-01-
170 *170* Packaging Packaging		Identify as per dwg & St Memo	ock Location T	0.00				YX				13-01
¹80 *1 8∩*		QC21- Final Inspection	- Work Order Release	0.00					Aa.	7	13-0	7-15
QC		Memo		0.00					_ا ^ر ا اب		1_5_0	

Quality Control

MLJ 13-07-15

											DQA	: Date	::
NCR:	Yes	/ No	•			WORK ORDER NON-	CO	NFOR	MANCE / UP	DATE			
								,		·	QA Closed	: Date):
Work Ord	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
	•					Rework			Skid-tube	Crosstube	-4	Water Jet	Engineering
Part !	NO.					Scrap Use-as-is	-	1	Machining noforming	Small Fab Finishing	4	od. Eng. Coor. pre/Packaging	Quality Other
NCR I	No.			 		. Work Order Update	_		Large Fab	Composite	, Rec/sto	Supplier	Other
Root					Descri	ption of work order update	T	Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Cł	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator													
Material	Ш					,			٠.				
Setup	Ш	`.	,										
Other	Ш												
Process													
Supplier]										
Training			İ										
Unapproved								<u></u>					
			. ,4				FAU	LT CATE	GORY				
Landi	ng (Gear				General		_				-	 -
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre N	ot Concei	ntric to (o/s	BOM/Route		Hardwa	ire		Over/Unde	r tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorr	ect	Weld
	<u></u>	Crushed/	Crimped			Burrs		⊣	ions Incomplete/	Unclear	Part Lost/N		Wrong Stock Pulled
		Cuffs				Contamination		_ Mainte	enance		Part Move	d	
		Heat Trea	at			Countersink		Mislabe	eled		Positioned	Wrong	_
		Inspectio	n Strip in	Tube		Cut Too Short	L	Misread	i		Power Loss	s/Surge	Other
		Ripples in	n Bend			Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drawing

Finish

Folio

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October-12-12 12:34:20 PM

Work Order ID:

91554

Parent Item:

D2932-1

Parent Item Name:

Saddle LH Out, 206

Start Date: 10/11/12

Required Date: 11/02/12

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP: B00.06.26New DWG rev, (mpp 2069)EC IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	20.0000	1	4			
Saddle Billet, 7075									<u> </u>	*/ ************************************			
				Location		Loc Qty	<u>L</u>	oc Code					
				MAT040		26							
•				7377	15	2		÷	·				
•				7378	80	7							
				7859	9	10							
				8076	55	0							
				MAT042		-7							
•				MAT044		1							
				7376	69	1							
				9123	8				- 7	2			•
				933/	9				-	- ว	FL	13/01	100

											DQA:	Date:	*
NCR:	Yes	/ No				WORK ORDER NON-O	O	NFORN	NANCE / UPDA				
									•		QA Closed:	Date:	
Work Orde	⊸r:					DISPOSITION	,			AGAINST DE	PARTMENT	PROCESS	
Part N	- No					Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite						Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		Initial	Action	n	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Descript	tion	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
							AUL	LT CATE	JORY				
Landi		ear Bending Centre No Cracks Crushed/ Cuffs Heat Trea	Crimped.		o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink		4	on Incomplete ions Incomplete/Und nance		Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned N	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
		Inspection	n Strip in	Tube		Cut Too Short		Misread	.		Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

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DART AEROSPACE LTD	Work Order:	91554
Description: 206 Saddle, Outboard, Left side	Part Number:	D2932-1
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Re	corded Act	ual Dimens	ons		
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.100	0.140		.123	.120	. 120	-120		
В	0.100	0.140		0124	.120	051.	0120		
С	0.100	0.140		6118	0118	.120	,120		
D	0.210	0.230		.219	, 221	8150	. 220		
E	1.245	1.255		1.250	1,250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1,250	1.250		
G	2.495	2.505		2,500	2,500	2,500	2,500		
Н	0.510	0.515		°215	.512	- 512	- SAB	512	
1	1.572	1.582		1, 577	1.577	1.577	1.577		
J	2.495	2.505	_	2,500	2,500	2,500	2.500		
K	0.257	0.262		.258	. 258	0258	258		
L	0.312	0.317		-314	,314	.314	e314		
M	0.235	0.240		. 238	238	,238	<i>23</i> 8		
N	0.100	0.140		811.	- 123	. 120	-120		
0	0.540	0.560		. 551	-551	-551	.550		
Р	0.490	0.510		- 501	.501	.508	യ		
Q	3.715	3.725		3,720	3,720	3.720	3.720		
R	2.470	2.510		2,491	2.401	2.491	2,491		
S	0.240	0.270		.250	.251	-250	-250		
T	0.100	0.180		· 135	.135	135	•135		
U	1.625	1.635		1,630	1,630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	·316	olE.	316		
Х	1.125	1.145		1.134	1. 138	1.135	1, 135		
Υ	1.565	1.585		574	1.578	1.5745	1,5745		
Z	0.178	0.198		881.	881.	-188	. 185		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
АН									
	Acc	ept/Reje	ct				OAS		

			14_	
Measured by:	F.K	Audited by	<i>9</i> -89	
Date:	13/01/10	Date:	13/0	1/10

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	21
С	07.03.21	Revised per drawing revision C	KJ/JLM OK	411

